

TECHNICAL DATA SHEET

HOT MELT ADHESIVE

DESCRIPTION

This product is an amorphous hot melt that exhibits flexibility at -20 F and sag resistance at 250 F. It can also be foamed.

FDA STATUS: A letter is available upon request.

TYPICAL PHYSICAL PROPERTIES AND GENERAL INFORMATION

Property	Value
APPLICATION TEMPERATURE	350 deg. F
DENSITY	7.2 lb-mass/gal
HARDNESS (DMM)	62
SHELF LIFE	365 day
SOFTENING POINT	280 deg. F
SPECIFIC GRAVITY	0.86
VISCOSITY (@ 350 F)	4,212 cP
VISCOSITY (@ 375 F)	3,237 cP

APPLICATION CHARACTERISTICS

When used with foamed hot melt application equipment the temperature settings throughout the system may vary from 280 - 350 F depending on the design and output variables. Technical assistance may be required.

EQUIPMENT SUGGESTIONS

Any hot melt application equipment capable of maintaining the suggested adhesive temperature noted above at the required melt rates.

DIRECTIONS FOR USE

1. Flush previous hot melt out of equipment following recommended procedures.
2. Adjust application equipment to above suggested temperatures.
3. If premelting options are used, set this function at the lowest possible temperature and still be able to maintain the required adhesive temperature and melt rate.
4. The open time of this product may be increased slightly by raising the application temperature and decreased slightly by lowering the application temperature within a small range of temperature changes.
5. Adjust pump pressure for desired bead diameter (line speed and extrusion nozzle orifice affect bead diameter in conjunction with pump pressure).

CLEANUP INSTRUCTIONS

Consult the equipment manufacturer for cleanup procedures. After clean-up, flush the applicator thoroughly with hot melt to purge the system.

SAFETY INSTRUCTIONS

To minimize the risk of burns, we recommend the use of eye protection and protective clothing when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature above 400F. Prevent the build-up of vapors. Extinguish all sources of ignition during hot melt use.

Use in a well ventilated area. Consult material Safety Data Sheet for additional information.

CAUTION: EXTREME CARE SHOULD BE EXERCISED WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATE. Severe burns will result if skin contact occurs. When moving a hot melt from one location to another, it is suggested that protective gloves be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress and see a physician immediately

STORAGE AND HANDLING

Because this is 100% solids system, the shelf life of this product is classified as one year. We suggest that this product be stored in containers in an upright position in areas where ambient temperatures will not exceed 100F. Storage of this product at temperatures exceeding 100F may cause the product to block together, creating handling difficulties.

LIMITED WARRANTY AND TERMS

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

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LIMITATIONS OF REMEDIES AND DAMAGES -- FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

LIMITATION OF ACTIONS AND VENUE -- Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

CONDITIONAL ACCEPTANCE -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.